

5143984

mlp



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D3957-043**  
**Job Sheet 187865-A**



Part No: D3957-043

Job Qty: 11 pcs

Part Name: Hinge Assembly, Door LH Lower



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/19

Job Tracking No:

Due Date: 12/19/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: D3957 REV B IPP RevA: New issue DD verified by:EC IPP REV.B AS PER REV:B 18/12/12 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

| Op No | Operation                      | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                                |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 110   | QC 2                           | 11 pcs | 12/19/18   | 12/19/18 | 0.00      | 0.00    | QC 2 - 1              |           | 19-01-14 |
| 120   | QC 8                           | 11 pcs | 12/19/18   | 12/19/18 | 0.00      | 0.00    | QC 8 - 12             |           | 19-01-17 |
|       |                                |        |            |          |           |         | QC 8 - 14             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 17             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 20             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 25             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 3              |           |          |
|       |                                |        |            |          |           |         | QC 8 - 32             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 33             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 35             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 38             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 39             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 4              |           |          |
|       |                                |        |            |          |           |         | QC 8 - 44             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 45             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 49             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 58             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 8              |           |          |
|       |                                |        |            |          |           |         | QC 8 - 9              |           |          |
|       |                                |        |            |          |           |         | QC 8 - 68             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 67             |           |          |
|       |                                |        |            |          |           |         | QC 8 - 1 (A)          |           |          |
| 130   | Powdercoat - 1 White GI(A)-B4B | 11 pcs | 12/19/18   | 12/19/18 | 0.00      | 0.73    | Powdercoat - 1 - B4B  |           | 19-01-17 |
|       |                                |        |            |          |           |         | Powdercoat - 2 - B4B  |           |          |
|       |                                |        |            |          |           |         | Powdercoat - 3 - B4B  |           |          |
|       |                                |        |            |          |           |         | Powdercoat - 4 - B4B  |           |          |
| 140   | QC 3                           | 11 pcs | 12/19/18   | 12/19/18 | 0.00      | 0.00    | QC 3 - 10             |           |          |
|       |                                |        |            |          |           |         | QC 3 - 13             |           |          |
|       |                                |        |            |          |           |         | QC 3 - 15             |           |          |
|       |                                |        |            |          |           |         | QC 3 - 17             |           |          |

|  |  |  |  |                        |             |
|--|--|--|--|------------------------|-------------|
|  |  |  |  | Packaging 3 - 11 - B4B |             |
|  |  |  |  | Packaging 3 - 12 - B4B |             |
|  |  |  |  | Packaging 3 - 13 - B4B |             |
|  |  |  |  | Packaging 3 - 14 - B4B |             |
|  |  |  |  | Packaging 3 - 15 - B4B |             |
|  |  |  |  | Packaging 3 - 16 - B4B |             |
|  |  |  |  | Packaging 3 - 17 - B4B |             |
|  |  |  |  | Packaging 3 - 18 - B4B |             |
|  |  |  |  | Packaging 3 - 19 - B4B |             |
|  |  |  |  | Packaging 3 - 20 - B4B |             |
|  |  |  |  | Packaging 3 - 21 - B4B |             |
|  |  |  |  | Packaging 3 - 22 - B4B |             |
|  |  |  |  | Packaging 3 - 23 - B4B |             |
|  |  |  |  | Packaging 3 - 24 - B4B |             |
|  |  |  |  | Packaging 3 - 25 - B4B |             |
|  |  |  |  | Packaging 3 - 26 - B4B |             |
|  |  |  |  | Packaging 3 - 27 - B4B | MAR 07 2019 |
|  |  |  |  | Packaging 3 - 28 - B4B |             |
|  |  |  |  | Packaging 3 - 29 - B4B |             |
|  |  |  |  | Packaging 3 - 30 - B4B |             |
|  |  |  |  | Packaging 3 - 31 - B4B |             |
|  |  |  |  | Packaging 3 - 32 - B4B |             |
|  |  |  |  | Packaging 3 - 33 - B4B |             |
|  |  |  |  | Packaging 3 - 34 - B4B |             |
|  |  |  |  | Packaging 3 - 35 - B4B |             |

|                |        |          |           |                 |                |
|----------------|--------|----------|-----------|-----------------|----------------|
| 180 QC 21 - SA | 11 pcs | 12/19/18 | 0.00 0.00 | QC 21 - SA - 21 | DAS            |
|                |        |          |           | QC 21 - SA - 70 | 21 MAR 07 2019 |

M1389 17 - Part Op 130 - \*\*\*MASK HOLES PRIOR TO POWDER COAT AS PER DWG NOTE 8\*\*\* START TIME: 3:30 OVEN  
Descriptions: TEMPERATURE: 360 FINISH TIME: 3:40  
150 - 1-Install Helicoil in D3957-3 as per dwg. 2-Install Rod end and Nut Loosely

| Job BOM     |                      |               |                         |           |
|-------------|----------------------|---------------|-------------------------|-----------|
| Part / Item | Component Name       | Quantity      | Operation               | Container |
| D3518-3ZV   | Ball Joint End st088 | 11 pcs (1 ea) | 150-Small Fab - 2 - B4B | 5138939   |
| MS124818    | Helicoil st37        | 11 pcs (1 ea) | 150-Small Fab - 2 - B4B | 5139894   |
| NAS509-6    | Nut GA200            | 11 Ea (1 ea)  | 150-Small Fab - 2 - B4B | 5139855   |

|                                   |  |                      |  |
|-----------------------------------|--|----------------------|--|
| DART AEROSPACE LTD                |  | Work Order:          |  |
| Description: Hinge, Door LH Lower |  | Part Number: D3957-3 |  |
| Inspection Dwg: D3957 Rev: A      |  | Page 1 of 1          |  |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension     | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-----------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.69                  | +/-0.030      | .690             | ✓      |        | SLIO                 | Vein     |
| 0.281                 | +/-0.010      | .280             | ✓      |        |                      |          |
| 0.281                 | +/-0.010      | .278             | ✓      |        |                      |          |
| 3.00                  | +/-0.030      | 3.000            | ✓      |        |                      |          |
| R0.13                 | +/-0.030      | .130             | ✓      |        | Rad gauge            |          |
| 0.563                 | +/-0.010      | .564             | ✓      |        |                      |          |
| 1.25                  | +/-0.030      | 1.259            | ✓      |        |                      |          |
| 1.93                  | +/-0.030      | 1.932            | ✓      |        |                      |          |
| 107°                  | +/-0.5°       | 107°             | ✓      |        | Protractor           |          |
| <del>.307</del> 0.250 | +/-0.010      | .306             | ✓      |        |                      |          |
| Ø0.203                | +0.005/-0.001 | .204             | ✓      |        |                      |          |
| 1.170                 | +/-0.010      | 1.170            | ✓      |        |                      |          |
| 0.39                  | +/-0.030      | .382             | ✓      |        |                      |          |
| 0.33                  | +/-0.030      | .323             | ✓      |        |                      |          |
| Ø0.063                | +0.004/-0.001 | .063             | ✓      |        |                      |          |
| 0.125                 | +/-0.010      | .121             | ✓      |        |                      |          |
| 0.094                 | +/-0.010      | .092             | ✓      |        |                      |          |
| 0.12                  | +/-0.030      | .120             | ✓      |        |                      |          |
| R0.50                 | +/-0.030      | .500             | ✓      |        | Rad gauge            |          |
|                       |               |                  |        |        |                      |          |
|                       |               |                  |        |        |                      |          |
|                       |               |                  |        |        |                      |          |

|                                             |                         |                     |     |
|---------------------------------------------|-------------------------|---------------------|-----|
| Measured by: <div>DAS<br/>20<br/>9-89</div> | Audited by: <div></div> | Prototype Approval: | N/A |
| Date: 19-01-12                              | Date: 19/01/17          | Date:               | N/A |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 09.11.13 | New Issue | KJ         |          |

